



Dart Aerospace Ltd.
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D3257-1**Job Sheet 193509****Part No:** D3257-1**Job Qty:** 12 pcs**Part Name:** Fitting**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/16/19**Job Tracking No:****Due Date:** 4/26/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV B IPP: A 04.04.14 New issue KJ/RF**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs	4/26/19	4/26/19	0.00	0.01	Bandsaw - 1		B. 19-04-25
110	HAAS 4 Axis - B4B	12 pcs	4/26/19	4/26/19	0.58	12.00	HAAS - 1 - B4B		B. 19-04-25
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	12 pcs	4/26/19	4/26/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

**Container No:** S175901**Part:** D3257-1**Job No:** 193509**Serial No/Batch:** S175901**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Date: 04/27/19

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
130	QC 8	12 pcs	4/26/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
140	Packaging 3-1 - Stock - B4B	12 pcs	4/26/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B

APR 19/04/27

APR 27 2019

				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	12 pcs	4/26/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	27
				QC 21 - SA - 53	APR 29 2019
Part Op 100 - (Bandsaw) Descriptions: 110 - (HAAS CNC Vertical Machine) 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Identify as per dwg & Stock Location: _____) 150 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303B0.500X0.500	AISI 303 Bar .500 x .500	1.3104 ft (.1092 ea)	100-Bandsaw - 1	5144619	
<i>cut blank at 1.312</i>					
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M303B0.500X0.500	1	12	0	
Part Specifications					
Specifications could not be found.					

MAT
used
1.361

Plex 4/16/19 9:19 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 193009
Description: Fitting		Part Number: D3257-1
Inspection Dwg: D3257	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.128	+/-0.010	0.128	✓		Ver	
0.145	+0.000/-0.005	0.142	✓		G.P.	
0.330	+/-0.010	0.330	✓		Ver	
Ø0.191	+0.005/-0.001	Ø0.191	✓		G.P.	
0.887	+/-0.010	0.886	✓		Ver	
Ø0.230 x 100°	+/-0.010	Ø0.230 x 100°	✓		Ver	
0.400	+/-0.015	0.400	✓		Ver	
0.400	+/-0.015	0.400	✓		Ver	
0.46	+/-0.030	0.440	✓		Ver	

Measured by: DAS 52 Date: 19/04/24	Audited by: [Signature] Date: 19/04/27	Preliminary Approval: Date:
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Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.06.20	0.455 dimension removed	KJ/JLM	
C	12.05.15	Dimensions revised per Dwg Rev B	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					